

Repair Thru July 16

Work Order ID 50506



Page 1

July 10, 2009 2:57:56 PM

PROTOTYPE

Accept



Setup Start



Item ID: D3955-041

Revision ID: A-PROTO

Stop



Item Name: Doubler Assembly

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3955

A-PROTO

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3955-1

Dwg Rev: *A-Proto*

Prog Rev: *A-Proto*

2-Deburr if necessary

0.00

0.00

0.00

110

QC2- Inspect parts off machine FAI/FAIB



QC

Quality Control

Memo

m/ 09 07 15 (1)

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Item ID: D3955-041

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Setup Start

Stop

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							
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QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

130		0.00							
-----	--	------	--	--	--	--	--	--	--



Small Fab	Memo	0.00							
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Small Fab 1- C'sink holes as per dwg

2- Deburr if necessary

140	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

**ENGINEERING
APPROVAL**

06/11/09.07.16

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Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finish

Memo

0.00

Hand Finishing

N/A 09.07.16

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

N/A 09.07.16

170

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

09.07.16

Abstract

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Setup Start

Stop

**Cust Item ID:**

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

0.00

10-10-68

Small Fab

Memo

0.00

SmallFab

1- Assemble nut plate as per dwg

190

0.00

11-11-11

OC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

200

0,00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

Mike
P. DOZOS Inc

W 92.07.17

Work Order ID 50506

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Item ID: D3955-041

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Doubler Assembly

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/07/21

DB955.041

Status	Item ID	Rev	Name	Start Date	Quantity	PeJONp Date	Secrap ap	Qua	mm	ind	NEC	IECX	ISort	me	Offsean	Ty1	Per	Och	to	Vore	Ce	Last	Idd	Da
✓	M6061T6S.063		6061-T6 .063 Sheet	7/07/09	0.3553	sf		100	5	0.0...	ml	09	07	15	1	09463	M...					7/0...	7/...	
✓	MS2042-3		Rivet	7/07/09	2.0000	Ea		170	0	0.0...	M7681			3		0	M...					7/0...	7/...	
✓	MS21086L3		Nut Plate	7/07/09	1.0000	Ea		170	0	0.0...	M112219			2		0	M...					7/0...	7/...	



DART AEROSPACE LTD	Work Order: 50506
Description: DOUBLED ASSY	Part Number: D3955-1
Inspection Dwg: D3955 Rev: A-Proto	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

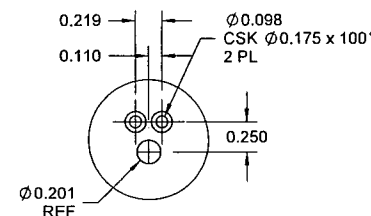
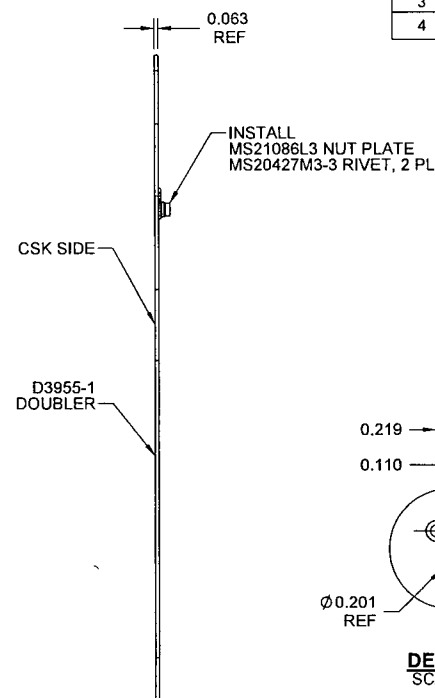
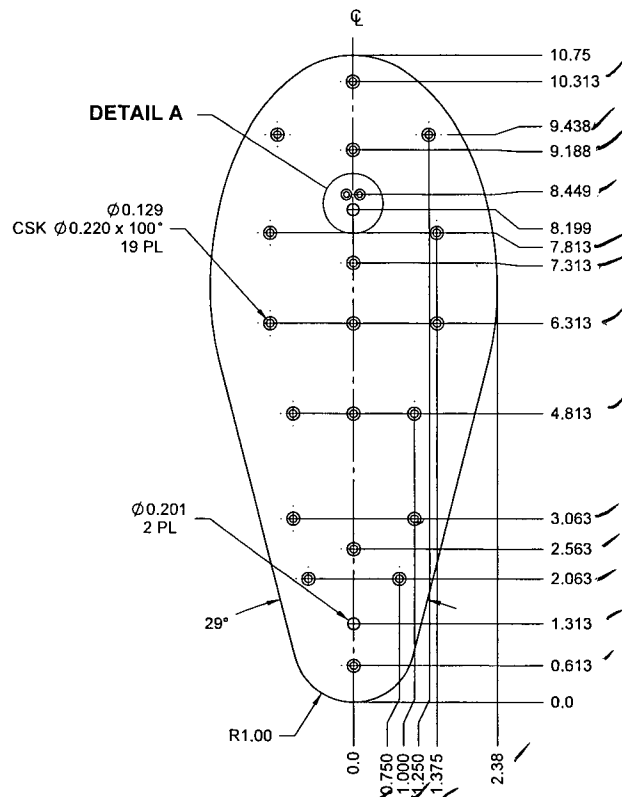
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.129	+0.005-0.001	0.130	✓		VWV	
Ø 0.201	+0.005-0.001	0.203	✓		VWV	
Ø 0.098	+0.005-0.001	0.100	✓		VWV	
10.75	+/- 0.030	10.74	✓		VWV	
1.000	+/- 0.010	1.004	✓		VWV	
1.375	+/- 0.010	1.377	✓		VWV	
2.563	+/- 0.010	2.557	✓		VWV	
7.313	+/- 0.010	7.310	✓		VWV	
0.22 lbs		0.2265	-		New goods	scale

Measured by:	Audited by:	Prototype Approval:
Date:	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



DETAIL A
SCALE 1:1

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09/06/32

D3955-041 DOUBLER ASSEMBLY

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.22 lbs

A	NEW ISSUE	RF	09.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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